

# Work Order ID 86020

June-19-12 4:04:19 PM

**\*86020\***

Page 1

Item ID: D3912-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Eyebolt

Start Date: 19/06/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3912

B

100

0.00

**\*100\***

Doosan

Memo

0.00

Doosan Lathe

TURN AS PER FOLIO FA871AND DWG

Prog Rev:

Dwg Rev: B

Deburr as required

SA 12/7/4

12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

SA 12/7/4

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86020

June-19-12 4:04:19 PM

**\*86020\***

Page 2

Item ID: D3912-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

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Stop **\*NS2\***

Item Name: Eyebolt

Start Date: 19/06/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				12			
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>470</u>  Memo	0.00  0.00				12x			<u>12/07/05</u>
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				OK			<u>12/7/06</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-19-12 4:04:24 PM

Page 1

Work Order ID: 86020

Parent Item: D3912-1

Parent Item Name: Eyebolt

\*86020\*

\*D3912-1\*

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R2.000

Purchased

No

100

f

14.3610

0.25

3.157895

\*M303R2 000\*

303 ROUND BAR 2"

\*\*

8 12714

Location

Loc Qty

Loc Code

MAT029

14.361

116656

1.427

116700

0.354

121846

12.58

304 R 2.000

2.3

115385

5.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	86020
<b>Description:</b> Eyebolt		<b>Part Number:</b>	D3912-1
<b>Inspection Dwg:</b> D3912	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13	+/-0.030	.130	/		SD-9	Ver
Ø0.700	+/-0.010	.699	/			
Ø0.500	+/-0.010	.498	/			
0.90	+/-0.030	.90	/			
0.13 x 45°	+/-0.030 x 0.5°	.13 x 45°	/			
0.22	+/-0.030	.215	/			
0.75	+/-0.030	.747	/			
0.970	+/-0.010	.967	/			
1.72	+/-0.030	1.717	/			
1.20	+/-0.030	1.202	/			
0.625	+/-0.010	.627	/			
2.23	+/-0.030	2.231	/			
R0.13	+/-0.030	R.125	/		R.G	
R0.015	+/-0.010	R.015	/		R.G	
0.625	+/-0.010	.631	/			
Ø0.650	+/-0.010	.651	/			
1.100	+/-0.010	1.097	/			
0.44	+/-0.030	.44	/			
R0.13	+/-0.030	R.125	/		R.G	
1.00	+/-0.030	1.003	/			
0.25	+/-0.030	.250	/			
0.88	+/-0.030	.884	/			
0.11	+/-0.030	.107	/			
Ø0.719	+0.010/-0.000	.723	/			

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	<i>[Signature]</i>	<b>Preliminary Approval:</b>	
<b>Date:</b>	12/7/14	<b>Date:</b>	12/10/15	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	
B	10.08.09	Dimensions revised per Dwg Rev B	KJ	<i>[Signature]</i>

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

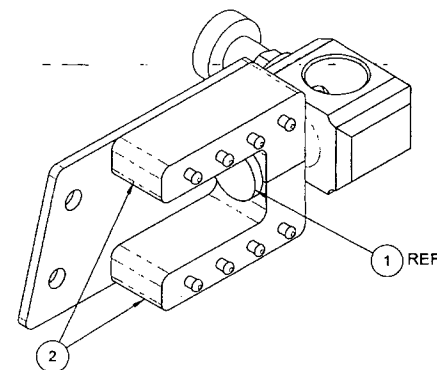
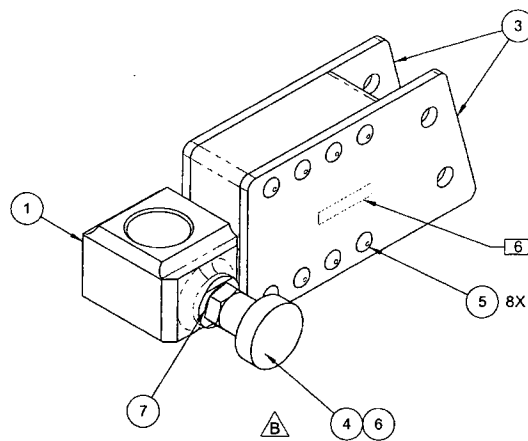
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



**SUPPLEMENTAL ISO VIEW**  
(EYEBOLT PLATE REMOVED  
TO SHOW INTERIOR FEATURES)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 06020 MLJ  
12/06/20

**RELEASED**  
2010-07-16

**D3912-041 EYEBOLT RECEIVER ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1.5		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.28		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B  
SHEET 1 OF 3  
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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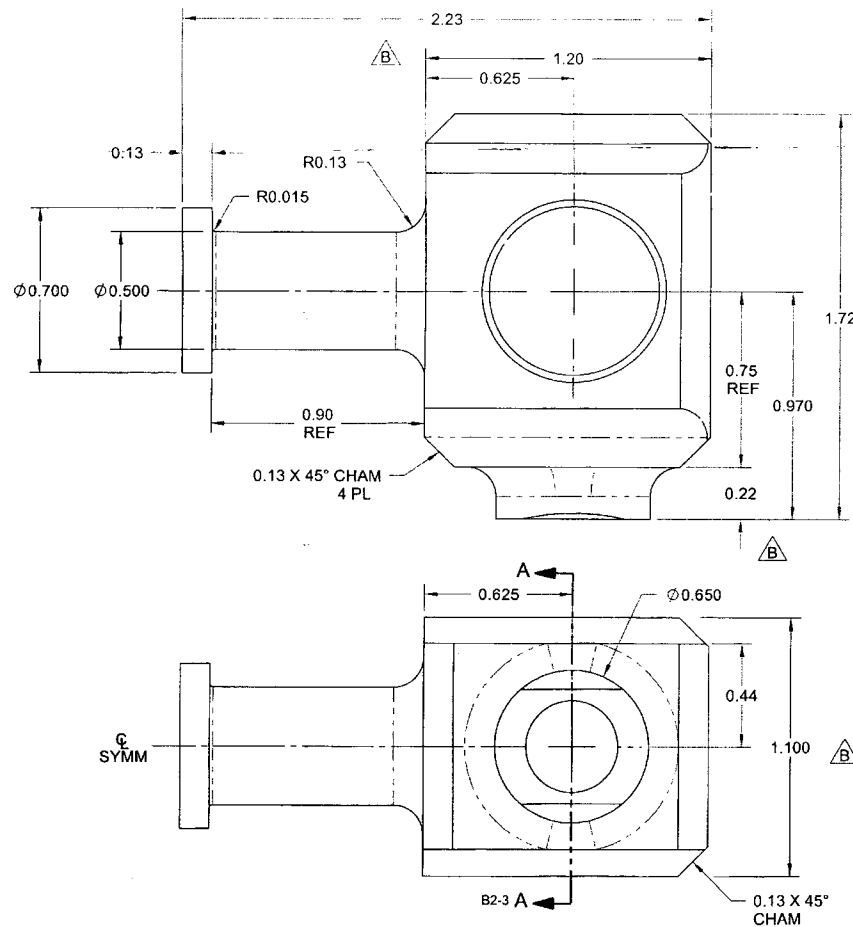
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

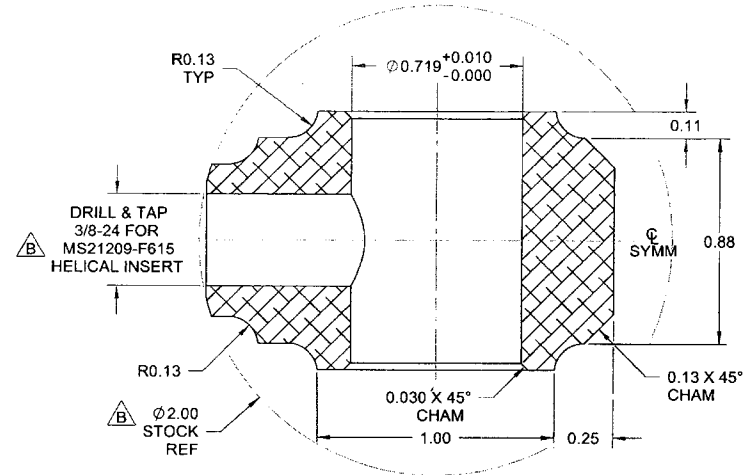
**NOTE:** Date & initial all entries



**D3912-1 EYEBOLT**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



**SECTION A-A B6-3**

**RELEASED**  
2010-07-16

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3912</b>	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		<b>EYEBOLT RECEIVER ASSY</b>	SCALE
DE APPR.			NTS
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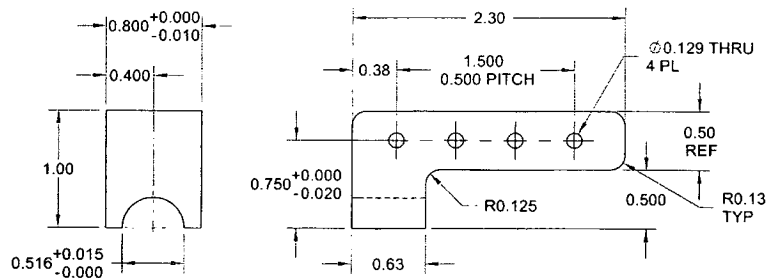
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

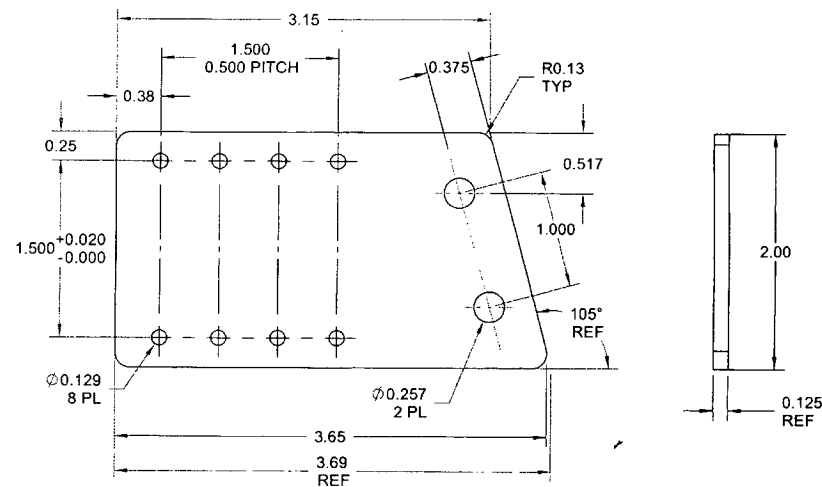
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3912-3 EYEBOLT BLOCK**



**D3912-5 EYEBOLT PLATE**

**NOTES:**

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240  
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs  
-5: 0.24 lbs

**RELEASED**  
2010-07-16  
JMD

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN	8/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	8/1	DRAWING NO. <b>D3912</b>	REV. B
MFG. APPR.	8/1		SHEET 3 OF 3
APPROVED	8/1	TITLE	SCALE
DE APPR.	8/1	<b>EYEBOLT RECEIVER ASSY</b>	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries